

20/2007 9:48:23 AM

Process Sheet

SP1.7

: CU-DAR001 Dart Helicopters Services
 : 34113
 Estimate Number : 11745
 P.O. Number :
 This Issue : 8/20/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 33225
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-01-06 JLM

Drawing Name : LUG ASSEMBLY
 Part Number : D3394043
 Drawing Number : D3394 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 8/27/2007

Qty: 20 40 Units Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0735 f(s)/Unit Total: 2.9400 f(s)

D2423 Lug Extrusion

Batch: B33310 C207108120

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blank to .850"

3.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Send Blanks To: Metec/Mast Precision Machining

P/O: 4404 C207108120 (40)

Machine D3394-3 as per Dwg D3394

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage E207109107(20)

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK C207109112(40) caution



Date: Monday, 8/20/2007 9:48:23 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 34113

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/09/13 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Issue PO 4585 Part Deflect Blue (18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

QC4 Inspect Paint AS Per ASTM

07/09/13 counter (18)

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS35489-93 Grommet M103688 x 18mm, m 105792 x 18mm

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

MF 07-09-28 (18)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter (18)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

7/9/28 18 SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.01

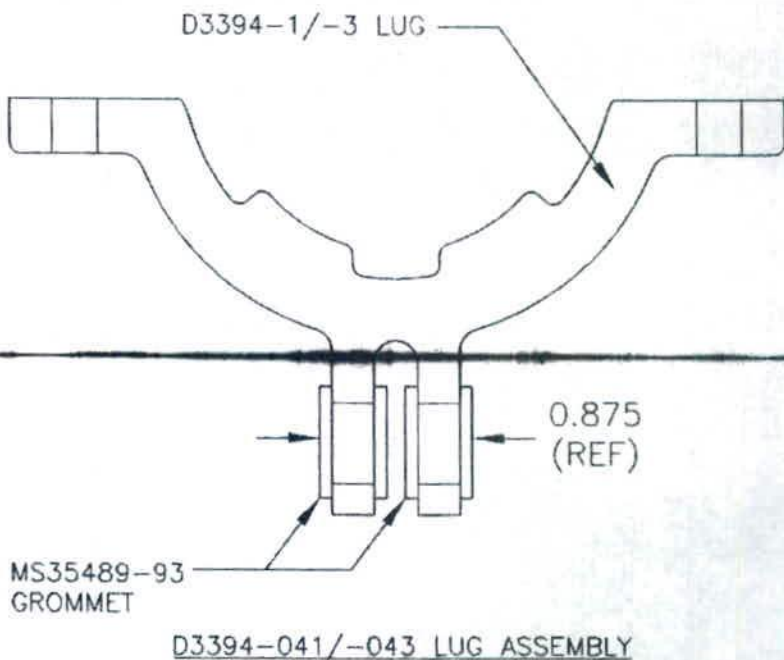
Job Completion



07.10.01

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3394
DATE 05.02.14	TITLE LUG	SHEET 1 OF 3
A	05.02.14	NEW ISSUE



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

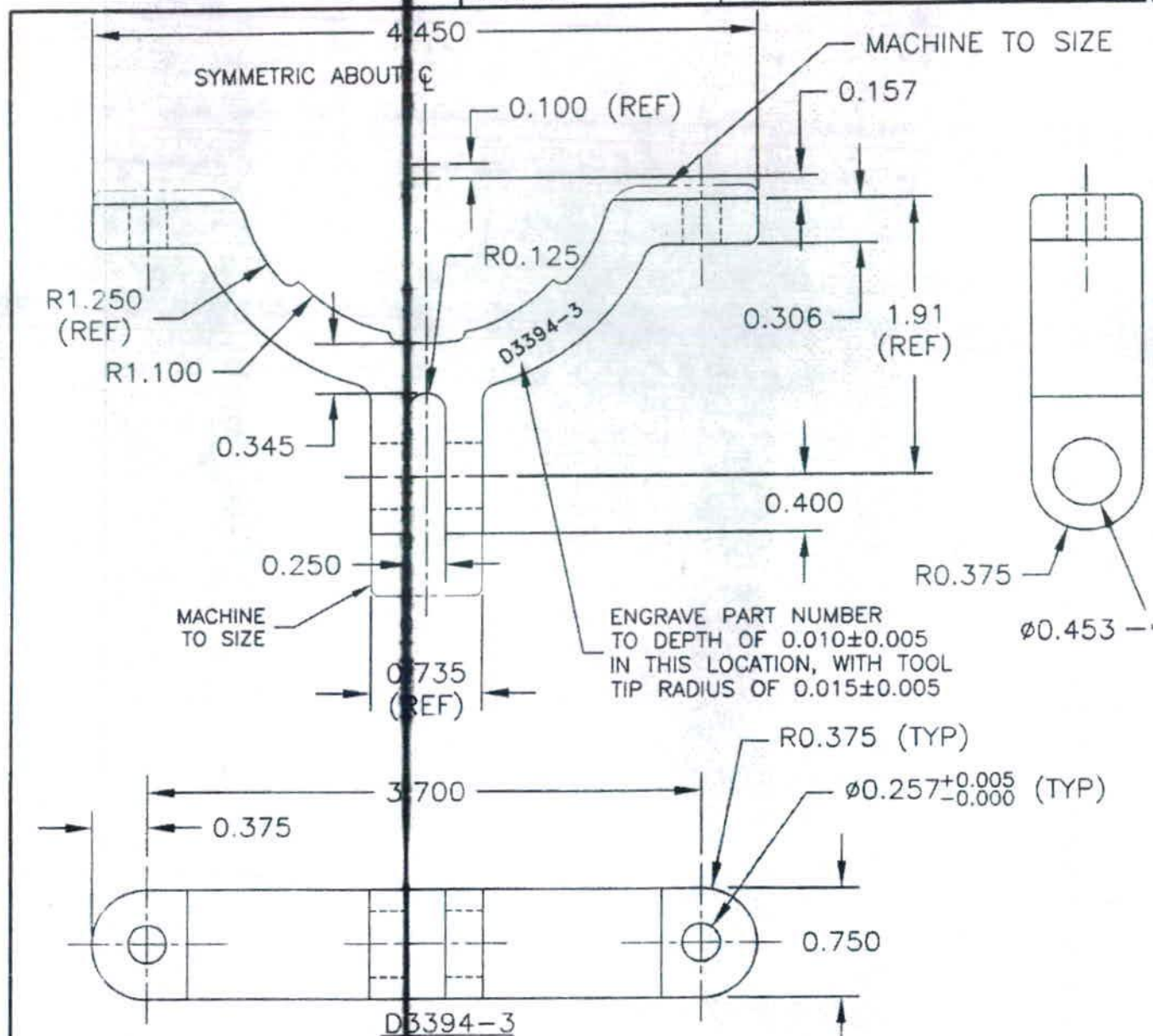
QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

w/o i 3113

RELEASED

05.11.14

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3394	REV. A SHEET 3 OF 3
DATE 05.02.14		TITLE LUG	S/ ALB 1:1



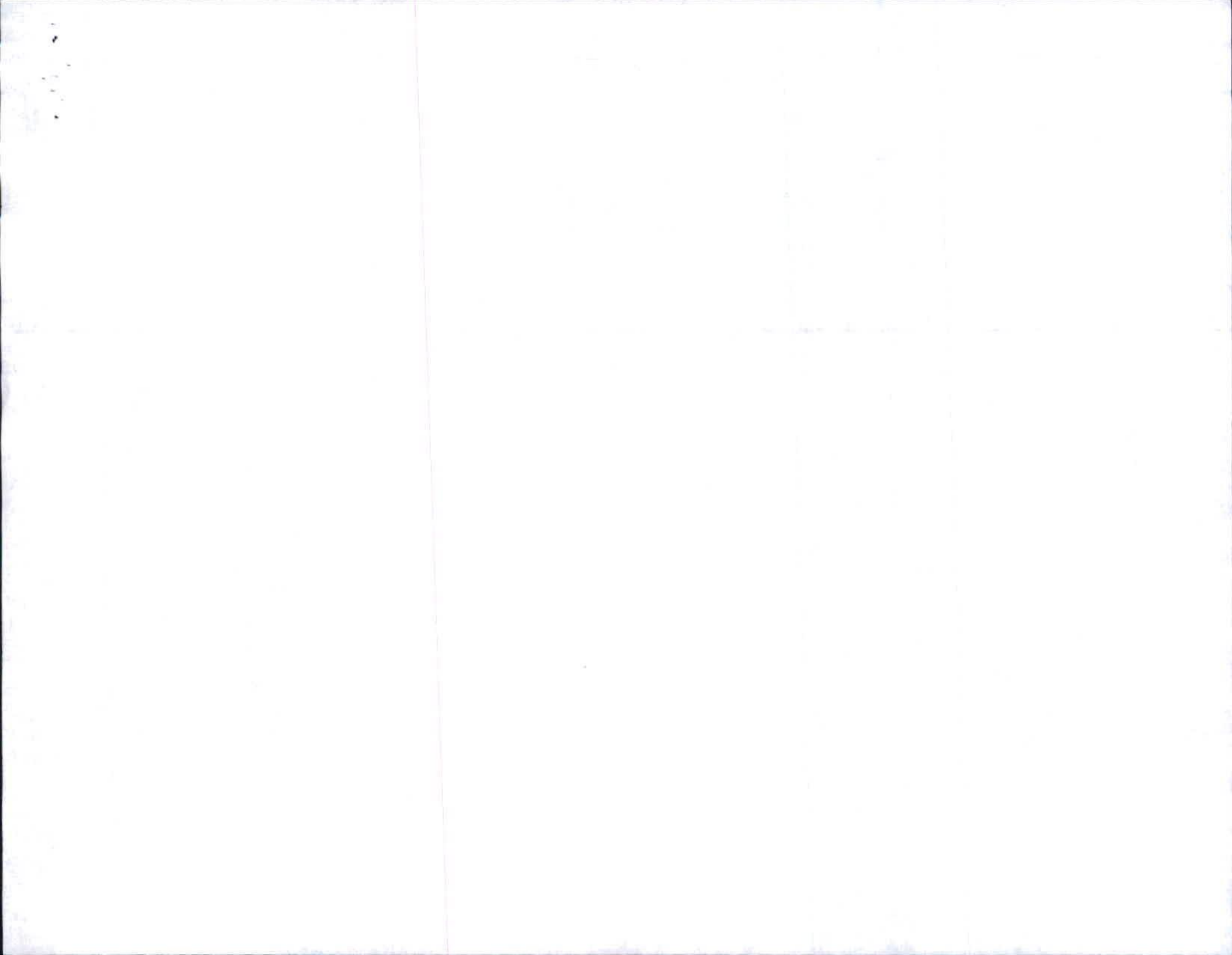
1) MAKE FROM EXTRUSION D2423
2) BREAK ALL EDGES 0.000-0.015
3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05-11-14

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





20 Terry Fox Drive
Vankisek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

16130

Date:

Sep 07, 2007

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Jean-Luc Ménard 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4404	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3414 3	Lug Assembly, material supplied precut	Each	99	100	
D2731 3	Mounting Lug	Each	50		
D3394 3	Lug ✓	Each	40	20	
<i>CP 07/09/07</i>					

Thank you for your order!

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

20

D3394-3

Lug

MATERIAL: supplied by DART D2423 B33310

NUMBER

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Sigi Walz
Sigi Walz

Wankleek Hill, September 7, 2007

